



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7703

Job Sheet 203278



Part No: 647.7703

Job Qty: 10 pcs

Part Name: Strut Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/14/19

Job Tracking No:

Due Date: 12/12/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A2 IPP REV:A 15.01.07 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
120	Large Fab - Welded Assy-1	10 pcs	12/12/19	12/12/19	0.00	3.95	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		MV Dec 24/19
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
130	QC 9	10 pcs	12/12/19	12/12/19	0.00	0.00	QC 9 - 10		
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		EL
							QC 9 - 9		
140	QC 5	10 pcs	12/12/19	12/12/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		



Container No: S243472



Part No: 647.7703

Job No: 203278

Serial No/Batch: S243472

Revision: Rev A2

Inspector:

Dart Aeros
1270 Aberdeen
Hawkesbury,
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

Plex 11/14/19 8:01 AM Dart.lajeunesse.marie

				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	62
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
150	Outsource - 3 - Cadplate	10 pcs	12/12/19	GRO002-VC	10 2020-01-02
160	Packaging 2-1 - Receive - B4B	10 pcs	12/12/19	0.00 0.00	Packaging 2 - 1 - B4B
					Packaging 2 - 2 - B4B
					Packaging 2 - 3 - B4B
					Packaging 2 - 5 - B4B
					Packaging 2 - 4 - B4B
					Packaging 2 - 6 - B4B
					Packaging 2 - 7 - B4B
					Packaging 2 - 8 - B4B
					Packaging 2 - 9 - B4B
					Packaging 2 - 10 - B4B
					Packaging 2 - 11 - B4B
					Packaging 2 - 12 - B4B
					Packaging 2 - 13 - B4B
					Packaging 2 - 14 - B4B
					Packaging 2 - 15 - B4B
					Packaging 2 - 16 - B4B
					Packaging 2 - 17 - B4B
					Packaging 2 - 18 - B4B
					Packaging 2 - 19 - B4B
					Packaging 2 - 20 - B4B
					Packaging 2 - 21 - B4B
					Packaging 2 - 22 - B4B
					Packaging 2 - 23 - B4B
					Packaging 2 - 24 - B4B
					Packaging 2 - 25 - B4B
					Packaging 2 - 26 - B4B
					Packaging 2 - 27 - B4B
					Packaging 2 - 28 - B4B
					Packaging 2 - 29 - B4B
					Packaging 2 - 30 - B4B
					Packaging 2 - 31 - B4B
					Packaging 2 - 32 - B4B
					Packaging 2 - 33 - B4B
					Packaging 2 - 34 - B4B
					Packaging 2 - 35 - B4B
					Packaging 2 - 36 - B4B
170	QC 6	10 pcs	12/12/19	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
					QC 6 - 81
					DAS 40
					JAN 16 2020 9-50
					DAS
180	Spray Paint - 2 - B4B	10 pcs	12/12/19	0.00 0.57	Spray Paint - 1 - B4B
					Spray Paint - 2 - B4B
					Spray Paint - 3 - B4B
					Spray Paint - 4 - B4B
190	QC 14	10 pcs	12/12/19	0.00 0.00	QC 14 - 15
					QC 14 - 2
					QC 14 - 34
					QC 14 - 41
					QC 14 - 51

					QC 14 - 58	
					QC 14 - 59	
					QC 14 - 9	
					QC 14 - 68	
					QC 14 - 40	
					QC 14 - 19	
					QC 14 - 43	DAS 81
					QC 14 - 24	9-89
					QC 14 - 61	JAN 20 2020
					QC 14 - 81	
200	Packaging 3-1 - Stock - B4B	10 pcs	12/12/19	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	DAS 84
					Packaging 3 - 23 - B4B	JAN 19 2020 << 114
					Packaging 3 - 24 - B4B	9-89
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
210	QC 21 - SA	10 pcs	12/12/19	0.00 0.00	QC 21 - SA - 21	DAS 21
					QC 21 - SA - 70	9-89
					QC 21 - SA - 53	JAN 20 2020

Part Op 120 - Weld per dwg A/R 4130 rod Batch M127925 - 1- ASSEMBLE AND WELD AS PER DWG ***IMPORTANT
 Descriptions: DIMENSION IS 8.35" ***

130 - QC9- Inspect visual per QSI004- Fusion Welds

140 - QC5- Inspect part completeness to step on W/O

150 - Issue P/O : 45378 Group Altech CAD PLATE IAW QQ-P-416F CLASS I TYPE II ****NOTE: limite cad
 platting on thread to 0.003" or less****

160 - Receive & Inspect for Damage & Mat'l Certs

170 - INSPECT USING GO/NO GO GAUGE

180 - Spray Paint / NDT Room - PRIOR TO PRIME MASK THREAD AND PRIME AS PER DWG 5195271

190 - QC14- Inspect Spray Paint

200 - Identify as per dwg & Stock Location: _____

210 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
647.7712	Strut Tube	10 pcs (1 ea)	120-Large Fab - Welded Assy-1	\$240366
647.7713	Strut Thread	10 pcs (1 ea)	120-Large Fab - Welded Assy-1	\$242195
647.7714	Strut Tube	10 pcs (1 ea)	120-Large Fab - Welded Assy-1	x8 \$219908 / x4 \$277202

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-Large Fab - Welded Assy-1	647.7712	10	17	0
	647.7713	10	10	0
	647.7714	10	8	0

Part Specifications

Specifications could not be found.

Plex 11/14/19 8:01 AM Dart.lajeunesse.marie

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045378



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB045378

PO Date: 12/12/19

Due Date: 1/10/20

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pynt Terms: Net 60

Freight Terms:

Special Comments:

E-MAILED
2020-01-06

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	204139	647.7701	647.7700 Rev A2	Strut Assembly : Various STC's Issue P/O : Group Altech CAD PLATE IAW QQ-P-416F CLASS I TYPE II Material - 4130; RC33 - NO baking required note: cad plate should not be too thick around tread	Firmed X10	-	1/10/20	10 pcs	0 pcs	10 pcs	\$13.75/pcs	\$137.50 He
2	202748	647.7702	647.7700 Rev A2	Strut Assembly : Various STC's Outsource3 (Outsource process-Cadplate per QSI017 4.1.9.1) Issue P/O Group Altech CAD PLATE IAW QQ-P-416F CLASS I TYPE II Material - 4130; RC 33; NO baking required note: cad plate should not be too thick around tread	Firmed X12	-	1/10/20	12 pcs	0 pcs	12 pcs	\$15.89/pcs	\$190.68 E



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB045378



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	203278	647.7703	647.7700 Rev A2	Strut Assembly : Various STC's Issue P/O Group Altech CAD PLATE IAW QQ-P-416F CLASS I TYPE II Material - 4130; RC 33 - NO baking required ****NOTE: limit cad plating on thread to 0.003" or less****	Firmed X12	-	1/10/20	12 pcs	0 pcs	12 pcs	\$14.75/pcs	\$177.00
											Grand Total:	
											\$505.18	

JAN 15 2020

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Handwritten signature: H. Guerin

Plex 1/6/20 8:43 AM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance

(025201-1)

2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

025201 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By	Transport / No de Compte Courier / Acc. No.	Bon de commande Client Customer Purchase Order No.				
14-Jan-2020		Jigar Patel		POHB045378				
#Ligne Line#	No. de Série / # Pièce Part Number / Line Item Details	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	À venir/ Back Order
1	647.7701 Rev.A2	647.7701 CAD YELLOW 500 [CADMIUM YELLOW 500] AS PER QQ-P-416F TYPE - 2, CLASS - 1 0.0005" THICKNESS CAD PLATE SHOULD NOT BE TOO THICK AROUND THREAD	CADMIUM CH	10	10	0	0	0
2	647.7702 Rev.A2	647.7700 CAD YELLOW 500 [CADMIUM YELLOW 500] AS PER IAW QQ-P-416F CLASS - 1, TYPE - 2 0.0005" (CAD PLATE SHOULD NOT BE TOO THICK AROUND THREAD)	CADMIUM CH	12	12	0	0	0
3	647.7703 Rev.	647.7703 01 -CAD YELLOW 0.0005 THICK OR LESS CAD PLATE IAW QQ-P-416F CLASS I TYPEII CAD PLATE SHOULD NOT BE TOO THICK AROUND TREAD MATERIAL STEEL LIMITE ON THREAD 0.003 THICK OR LESS	CADMIUM CH	12	12	0	0	0

RECEIVED
 JAN 14 2020
 DART AEROSPACE LTD.

Notes Additionnelles / Additional Notes

Epaisseur réelle
Actual Thickness

Inspecteur Qualité
Quality Inspector

Réçu par
Received By

Nous certifions que les pièces énumérées ci-dessus ont été traitées en conformité avec votre commande et vos spécifications et rencontrent les exigences.
 Notre responsabilité financière et légale ne sera pas supérieure au montant de la facture issue.

We hereby certify that the parts listed above have been process in accordance with your purchase order and specifications and are in conformance with your requirements.
 Our financial and legal responsibility will not be higher than the amount of invoice.